

# Work Order ID 76481

**\*76481\***

Page 1

November-15-11 1:00:08 PM

Item ID: D350-588-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Aft Door Fwd Hinge Modification

Start Date: 15/11/2011 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 09/12/2011 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 11/11/15

Tooling:

Date:

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
N/A	Rev N/A								
100	DOCUMENT CONTROL	0.00							
<b>*100*</b>									
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D350-588-011 CHG002								
110	Pick Kit	0.00							
<b>*110*</b>									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

*Handwritten:* MLJ 11-11-29 (10)

*Handwritten:* 11/11/26 (10)

*Handwritten:* (4/10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**Work Order ID 76481****\*76481\***

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Item ID: D350-588-011

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Aft Door Fwd Hinge Modification

Stop **\*NS2\***

Start Date: 15/11/2011 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 09/12/2011 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
<b>*130*</b>	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-588-011								
	Location: <u>122</u>								
	PPP Rev: <u>2</u>								
140									
<b>*140*</b>	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/11/2/6

102

11/12/11

MF 11-12-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 76481

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Parent Item: D350-588-011

**\*D350-588-011\***

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 15/11/2011

Required Date: 09/12/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:M04.08.31Added D2690-17KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN526C1032R7

Purchased

No

120

Each

212.0000

2

20

\*\*

**\*AN526C1032R7\***

Screw

Location

Loc Qty

Loc Code

ST328

32

116304

32

ST348

180

119436

30

119449

150

AN526C832R8

Purchased

No

120

Each

107.0000

8

80

\*\*

**\*AN526C832R8\***

Screw

Location

Loc Qty

Loc Code

ST309

100

118926

100

ST327

7

117735

7

AN526C832R9

Purchased

No

120

Each

466.0000

8

80

\*\*

**\*AN526C832R9\***

Screw

Location

Loc Qty

Loc Code

ST327

366

118422

16

118983

350

ST347

100

119623

100

2011/11/15

2011/11/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 15/11/2011

Required Date: 09/12/2011

Start Qty: 10.00

Required Qty: 10.00

AN960JDI0

NAS1149D0363J

Purchased

No

120

Each

0.0000

4 40

**\*AN960.ID10\***

Washer

AN960JD8

NAS1149DN832

Purchased

No

120

Each

0.0000

24 240

**\*AN960.ID8\***

Washer

D2143

Manufactured

No

120

Each

8.0000

1 10

**\*D2143\***

Hinge Bracket

Location

Loc Qty

Loc Code

ST198

8

64308

8

Manufactured

No

120

Each

21.0000

1 10

D2144

**\*D2144\***

Hinge Bracket

Location

Loc Qty

Loc Code

ST198

21

73553

21

Manufactured

No

120

Each

3.0000

D2150

**\*D2150\***

Packer Doubler, Hinge

Location

Loc Qty

Loc Code

ST006

3

69514

3

Manufactured

No

120

Each

0.0000

D2151

**\*D2151\***

Packer Doubler, Hinge

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D350-588-011

**\*D350-588-011\***

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 15/11/2011

Required Date: 09/12/2011

Start Qty: 10.00

Required Qty: 10.00

D2153  
S HD \*D2153\*  
Door Prop

Manufactured No 120 Each 41.0000

\*\*

Location Loc Qty Loc Code

ST272 41

71003 5

76056 36

Manufactured No 120 Each 12.0000

\*\*

Location Loc Qty Loc Code

ST006 12

64312 12

Manufactured No 120 Each 41.0000

\*\*

Location Loc Qty Loc Code

ST009 41

66139 2

73702 39

Manufactured No 120 f 501.7037

\*\*

Location Loc Qty Loc Code

ST402 501.7037

39782 6.5

55054 4

63880 7.6237

73644 483.58

D2461

**\*D2461\***

Neoprene "D" Seal

S HD

cut 1" X 87.00"

mt. measured 11/14/05

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*76481\***

Parent Item: D350-588-011

**\*D350-588-011\***

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 15/11/2011

Required Date: 09/12/2011

Start Qty: 10.00

Required Qty: 10.00

D2463      Manufactured      No      120      f      501.8188      7.25      76.31579  
**\*D2463\***      \*\*  
 Seal

Location	Loc Qty	Loc Code
ST404	501.8188	
64944	1.71	
66954	0.1088	
72232	500	

Manufactured      No      120      Each      22.0000

**\*D2583\***  
 Latch Bracket

Location	Loc Qty	Loc Code
ST017	22	
74073	22	

Manufactured      No      120      Each      90.0000

**\*D2585\***  
 Mounting Channel

Location	Loc Qty	Loc Code
ST017	90	
73297	24	
74488	66	

Manufactured      No      120      Each      97.0000

**\*D2586\***  
 Door Latch

Location	Loc Qty	Loc Code
ST204	97	
73296	57	
74489	40	

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D350-588-011

**\*D350-588-011\***

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 15/11/2011

Required Date: 09/12/2011

Start Qty: 10.00

Required Qty: 10.00

D2587

Manufactured No

120 Each

33.0000

1 10

\*\*

**\*D2587\***

Door Slug, 350 Hinge

Location

Loc Qty

Loc Code

ST017

33

74522

33

Manufactured No

120 Each

57.0000

\*\*

D2589

**\*D2589\***

Keys, Key Chain, 350 Hinge

Location

Loc Qty

Loc Code

ST018

57

58194

57

Manufactured No

120 Each

26.0000

\*\*

D2690-17

**\*D2690-17\***

Cable

Location

Loc Qty

Loc Code

ST020

26

66510

1

74380

5

76139

20

Manufactured No

120 Each

43.0000

\*\*

D2857-1

**\*D2857-1\***

Hinge Bracket

Location

Loc Qty

Loc Code

ST024

43

69932

19

75253

24

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 76481

**\*76481\***

Parent Item: D350-588-011

**\*D350-588-011\***

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 15/11/2011

Required Date: 09/12/2011

Start Qty: 10.00

Required Qty: 10.00

D2857-2

Manufactured No

120 Each

38.0000

**\*D2857-2\***

Hinge Bracket

\*\*

Location

Loc Qty

Loc Code

ST024

38

67001

14

75252

24

Manufactured No

120 Each

27.0000

D2858-1

**\*D2858-1\***

Hinge Bracket

\*\*

Location

Loc Qty

Loc Code

ST024

27

69595

9

75250

18

Manufactured No

120 Each

24.0000

D2858-2

**\*D2858-2\***

Hinge Bracket

\*\*

Location

Loc Qty

Loc Code

ST024

24

69594

7

75251

17

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 76481

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

\*76481\*

\*D350-588-011\*

Start Date: 15/11/2011

Required Date: 09/12/2011

Start Qty: 10.00

Required Qty: 10.00

FG-778150-550-ROL

Purchased

No

120

sf

3,847.231

1

10

\*\*

\*FG-778150-550-ROL\*

7781 9oz Glass 50"x125yd

## Location

## Loc Qty

## Loc Code

CA

2871.231

117602

1096.231

119099

1775

ST403

976

104845

3

108932

18

111166

392

113905

563

1- cut 1 square ft of glass cloth

MS20426AD3-4

Purchased

No

120

Each

4,810.000

12

120

\*\*

\*MS20426AD3-4\*

RIVET

## Location

## Loc Qty

## Loc Code

ST316

4810

104374

1100

110398

3710

MS20470AD4-5

Purchased

No

120

Each

2,424.000

18

180

\*\*

\*MS20470AD4-5\*

Rivet, Universal Head

## Location

## Loc Qty

## Loc Code

ST319

2424

116893

68

118405

2356

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D350-588-011

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Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 15/11/2011

Required Date: 09/12/2011

Start Qty: 10.00

Required Qty: 10.00

MS21042L08

Purchased

No

120

Each

333.0000

18

180

**\*MS21042I 08\***

Nut

## Location

## Loc Qty

## Loc Code

ST300

333

119109

283

119436

50

Purchased

No

120

Each

8,829.000

4

40

MS21042L3

**\*MS21042I 3\***

Nut

## Location

## Loc Qty

## Loc Code

ST300

297

117441

16

117885

35

118451

5

118927

241

ST516

6000

119017

6000

ST518

2532

119075

2532

Purchased

No

120

Each

103.0000

2

20

MS27039-08-11

**\*MS27039-08-11\***

Screw

## Location

## Loc Qty

## Loc Code

ST290

103

117441

103

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 15/11/2011

Required Date: 09/12/2011

Start Qty: 10.00

Required Qty: 10.00

MS27039-1-15

Purchased

No

120

Each

63.0000

2 20

\*\*

\*MS27039-1-15\*

Screw

Location

Loc Qty

Loc Code

ST291

63

118093

25

118574

38

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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## 52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

\* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

## 52.4 PARTS LISTS

588 -041	(588- 011)	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	1/2" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1-SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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52-00-00